



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PRELIMINARY ISSUE

D5622-3
Job Sheet 181056

Accounting Job RD18-1056-01



Part No: D5622-3

Job Qty: 1 ea

Part Name: Mid Wearshoe



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/20/18

Job Tracking No:

Due Date: 7/27/18

Created By: Marie Lajeunesse

Type: R+B Stock

Description:

Note: DWG.D5622 REV 9 Prelim NEW ISSUE 18/05/16 JFS VERIFIED BY:DD

Ship Via:

POSITIVE RECALL

EFFECTIVE 20 AUG 2018

RELEASED 19 DATE 18-08-2018

as per ECU 18-783

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/27/18	7/27/18	0.00	0.00	Start Up Waterjet		SC 18/07/23
110	Waterjet	1 pcs	7/27/18	7/27/18	0.00	0.06	Waterjet1		SC 18/07/23
120	QC	1 pcs	7/27/18	7/27/18	0.00	0.00	QC2 Waterjet-2		SC 18/07/23
130	QC	1 pcs	7/27/18	7/27/18	0.00	0.00	QC8-2		38
140	Brake NC	1 pcs	7/27/18	7/27/18	0.12	0.01	Brake NC 1		9-89
150	QC	1 pcs	7/27/18	7/27/18	0.00	0.00	QC5		18/08/02
160	Autoweld 1	1 pcs	7/27/18	7/27/18	0.00	0.03	Automated welding		DAS 22
170	QC	1 pcs	7/27/18	7/27/18	0.00	0.00	QC10		38 DAS
180	QC	1 pcs	7/27/18	7/27/18	0.00	0.00	QC5		9-89 38
190	HandFinish	1 pcs	7/27/18	7/27/18	0.00	0.03	HandFinish4		AR AUG 26 2018
200	QC	1 pcs	7/27/18	7/27/18	0.00	0.00	QC3		DAS AUG 27 2018 68
210	Packaging	1 pcs	7/27/18	7/27/18	0.00	0.00	Packaging3-1		6 DAS AUG 31 2018 9-89
220	QC21-SA	1 Ea	7/27/18	7/27/18	0.00	0.00	QC21		9-89 21 AUG 31 2018

Part Op 110 - 1-Cut D5622-3F as per Dwg D5622 Dwg Rev: 2 Prog Rev: 2 2-Deburr if necessary
Descriptions: 160 - ***SEE NOTE 8 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: 138886
190 - APPLY TEXTURED COATING ON CONCAVE SURFACE AS PER DWG AND QSI
BATCH: 138886
210 - LOCATION : FP001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	.1010 sf (.101 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S18GA	0	313	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

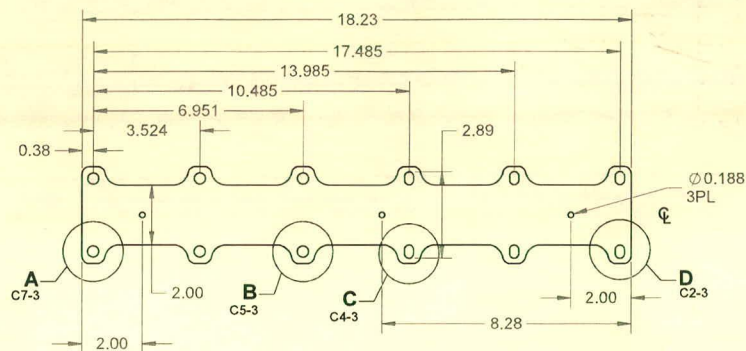
WORK ORDER NON-CONFORMANCE / UPDATE



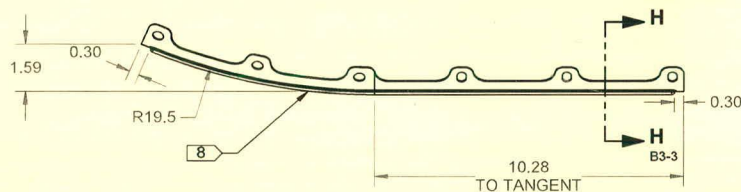
QA Closed: _____ Date: _____

Work Order update only ☐

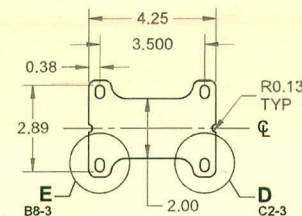
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		Container No: S095324 Part: D5622-3 Job No: 181056 Serial No/Batch: S095324 Revision: A prelim Inspector: _____ Exp Date: _____ Instructions: _____ Date: 07/23/18					
Description Work Order Deviation									
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> Pressure/Force ☐ Bending ☐ Centre Not Co ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%; vertical-align: top;"> Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> </tr> </table>				Pressure/Force ☐ Bending ☐ Centre Not Co ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mis-labeled ☐ Fit/Function ☐ Misaligned/off center ☐
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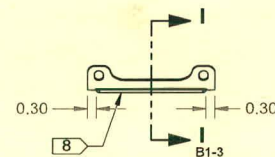
D5622-1F FLAT PATTERN



D5622-1 FWD WEARPAD
(MAKE FROM D5622-1F)



D5622-3F FLAT PATTERN



D5622-3 MID WEARPAD
(MAKE FROM D5622-3F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK (18 GAUGE)
PER AMD 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 SECTION 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5622-X" USING FINE POINT PERMANENT INK MARKER PER DART QSI 044 SECTION 6.1
- 7) WEIGHT: D5622-1 = 0.85 lbs, D5622-3 = 0.18 lbs
- 8) APPLY HARD SURFACING WELD BEAD 0.06-0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
APPLY HARD SURFACING WELD BEAD 0.06-0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILES D5622-1F_REV2.DXF & D5622-3F_REV2.DXF

APPROVED BY DESIGN MANAGER

A		NEW ISSUE		WK	18.04.18
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DESIGN	WK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			REV. A
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CHECKED	RF	DRAWING NO.			SHEET 1 OF 3
MFG. APPR.	DD	D5622			
APPROVED	HS	TITLE			SCALE
DE APPR.		WEARPAD			NTS
DATE	18.04.18			COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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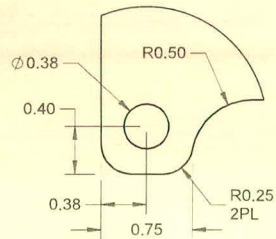
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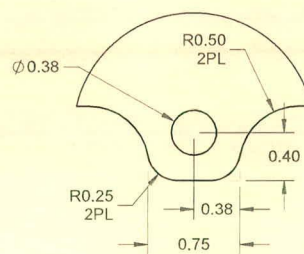
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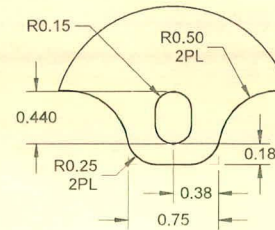
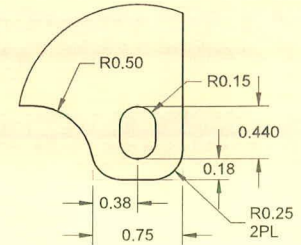
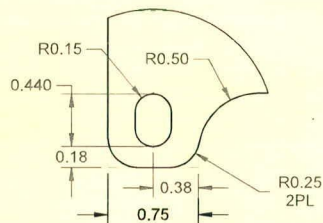
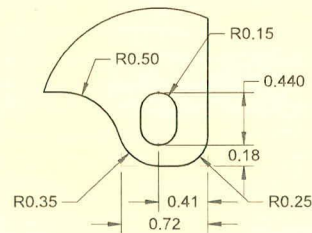
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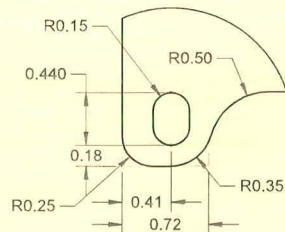
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**DETAIL B**

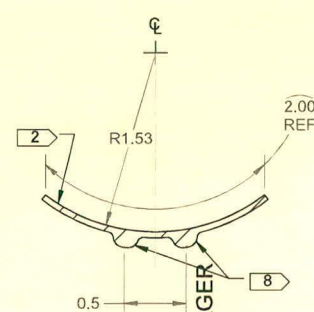
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**DETAIL C**C6-1
C3-2**DETAIL D**C2-1
C5-1**DETAIL E**C3-1
C3-2**DETAIL G**

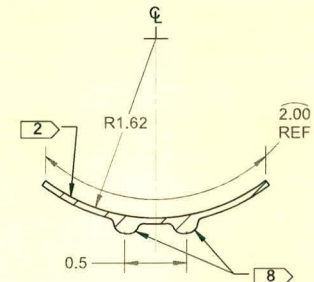
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**DETAIL F**

C7-2

**SECTION H**

B6-1

**SECTION I**B3-1
B3-2
B6-2

APPROVED BY DESIGN MANAGER

DESIGN	WK
DRAWN	WK
CHECKED	RF
MFG. APPR.	DD
APPROVED	HS
DE APPR.	
DATE	18.04.18

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D5622

TITLE

WEARPAD

REV. A

SHEET 3 OF 3

SCALE

NTS

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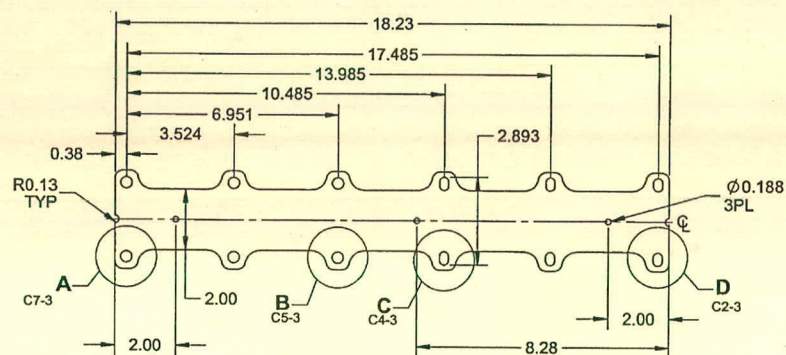
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Feb 19

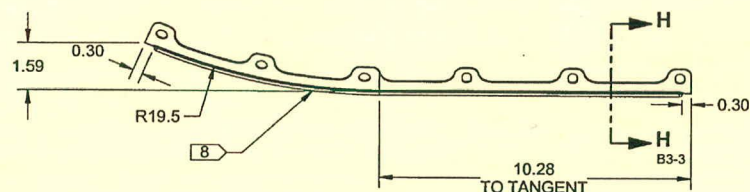
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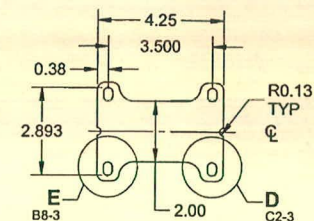
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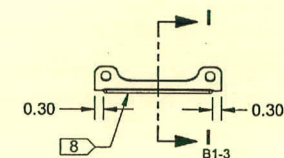
D5622-1F FLAT PATTERN



D5622-1 FWD WEARPAD
(MAKE FROM D5622-1F)



D5622-3F FLAT PATTERN



D5622-3 MID WEARPAD
(MAKE FROM D5622-3F)

RELEASED

2018 AUG 15
ECN 18-785

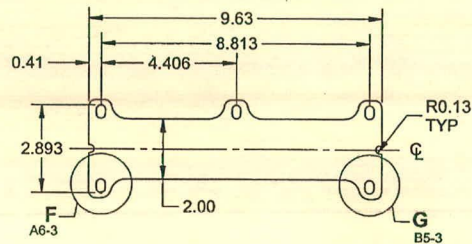
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S18GA
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 SECTION 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5622-X" USING FINE POINT PERMANENT INK MARKER PER DART QSI 044 SECTION 6.1
- 7) WEIGHT: D5622-1 = 0.85 lbs, D5622-3 = 0.18 lbs
- 8) APPLY HARD SURFACING WELD BEAD 0.06-0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
APPLY HARD SURFACING WELD BEAD 0.06-0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILES D5622-1F_REVA.DXF & D5622-3F_REVA.DXF

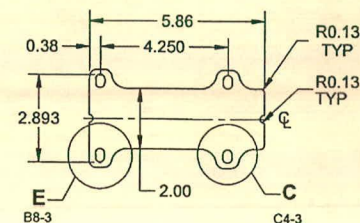
APPROVED

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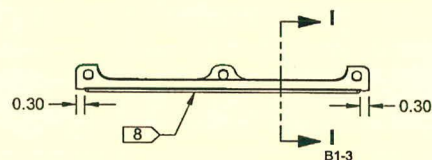
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CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	JFS	D5622	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPAD	NTS
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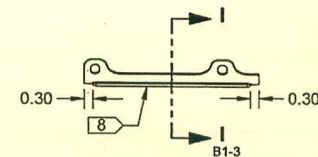
D5622-5F FLAT PATTERN



D5622-7F FLAT PATTERN



D5622-5 AFT WEARPAD
(MAKE FROM D5622-5F)



D5622-7 AFT WEARPAD
(MAKE FROM D5622-7F)

RELEASED

2018 AUG 15

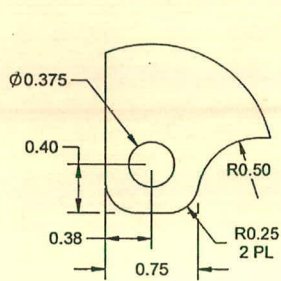
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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5622-X" USING FINE POINT PERMANENT INK MARKER PER ART QSI 044 SECTION 6.1
- 7) WEIGHT: D5622-5 = 0.40 lbs, D5622-7 = 0.25 lbs
- 8) APPLY HARD SURFACING WELD BEAD 0.06-0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
APPLY HARD SURFACING WELD BEAD 0.06-0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILES D5622-5F_REVA.DXF & D5622-7F_REVA.DXF

APPROVED

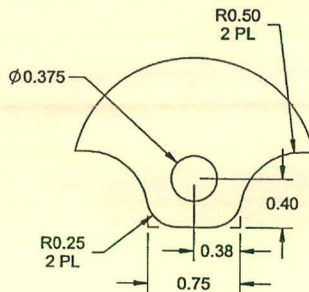
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MFG. APPR.	JFS	D5622	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPAD	NTS
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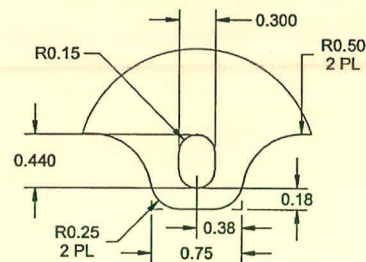
DETAIL A

C7-1



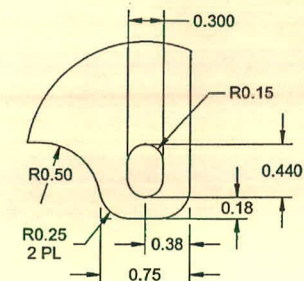
DETAIL B

C7-1



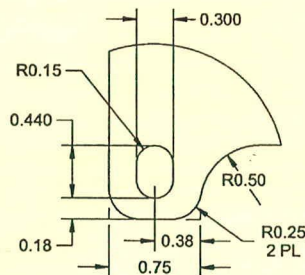
DETAIL C

C6-1
C3-2

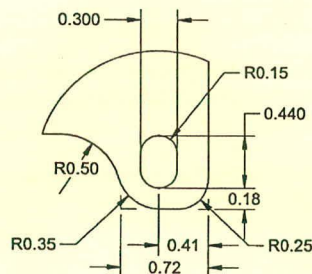


DETAIL D

C2-1
C5-1

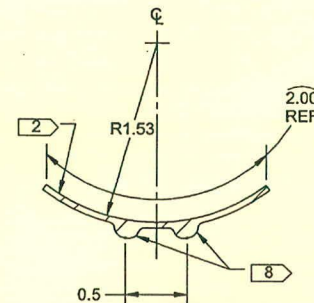


DETAIL E



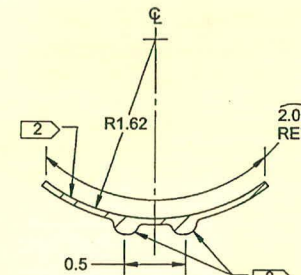
DETAIL G

C6-2



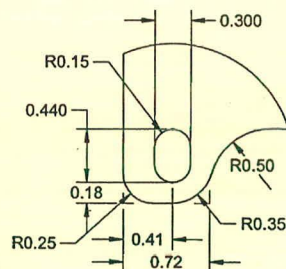
SECTION H-H

B6-1



SECTION I-I

B3-1
B3-2
B6-2



DETAIL F

C7-2

RELEASED

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